

Drp: Monday, 11/21/2005 7:45:49 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 24931	
Estimate Number : 10748	
P.O. Number : N/A	Part Number : D34635F
This Issue : 11/21/2005 S.O. No. : N/A	Drawing Number : D3463 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 11/28/2005 Qty: 4 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : EST REV. A 05.11.18 NEW ISSUE EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34635F

End Cap

et (35 sq in)



Pick
Mat'l: AISI 304/316 SS 0.060" thick sheet
(M304S166A) batch: M19059



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Step Flat Pattern

SB 05/11/22 4

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O:

Email or Ship DXF file to vendor

Laser Cut per Dwg D3463 flat pattern D3463-5F

Material release note required

1- Fabricate as per Dwg D3463

2- Deburn

SB 05/11/22 4

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

N/A

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

EC 05.11.23

4

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 05/11/23 4

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/11/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 7:45:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 24931

Part Number: D34635F

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DB 05/11/24 (4)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

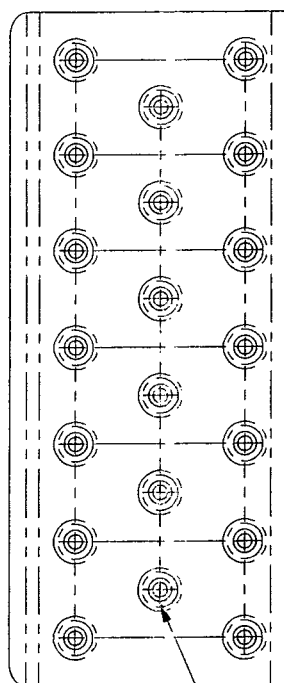
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

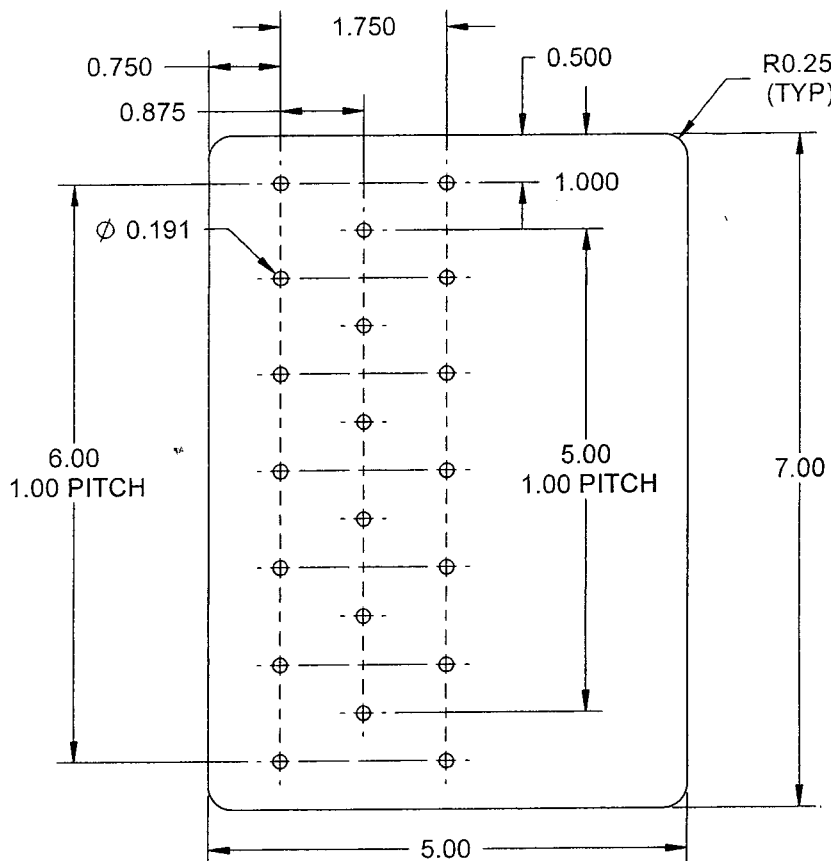
NOTE: Date & initial all entries

PRELIMINARY ISSUE

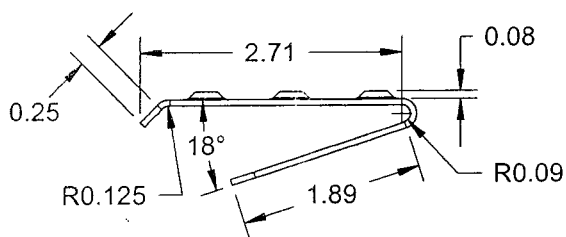
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3463	REV. A SHEET 4 OF 4
DATE 05.09.20		TITLE STEP WELDMENT	SCALE 1:2



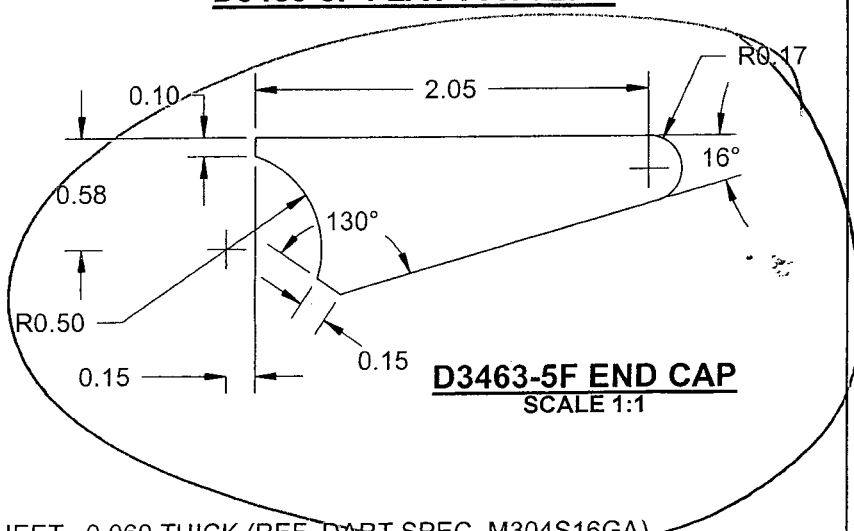
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKER SHARP EDGES 0.005 TO 0.010